

Date: Monday, 10/16/2006 2:02:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PROP ARM ASSEMBLY		
Job Number	: 29023					
Estimate Number	: 10730					
P.O. Number	: N/A			Part Number	: D2982041	
This Issue	: 10/16/2006	S.O. No.	: N/A	Drawing Number	: D2982 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	: PURCHASED PARTS	Drawing Revision	: B	
Previous Run	: 27507			Material	: N/A	
Written By	:			Due Date	: 11/10/2006	
Checked & Approved By	: <u>KJ</u> 06/10/06			Qty:	15	Um: Each
Comment	: EST rev A 00.06.05 New Issue EC EST rev B 06.05.05 ECN 797 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)	
		Clevis	
		Pick:	
	Qty Part number Description Batch	<u>B27522</u> X15	
2.0	D2022101	Spacer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)	
		Spacer	
		Pick:	
	Qty Part number Description Batch	<u>B26327</u> X30	
3.0	D2429041	Spring Clip Ass'y	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)	
		Spring Clip Ass'y	
		Pick:	
	Qty Part number Description Batch	<u>B29025</u> X15	
4.0	D2588	Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)	
		Bracket	
		Pick:	
	Qty Part number Description Batch	<u>B24637</u> X30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
5.0	D2730	Door Prop
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) Door Prop Pick: Qty Part number Description Batch 1 D2730 Prop arm <u>B24638</u> <u>x2</u> <i>mjl</i>
6.0	AN410A	Bolt
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) Bolt Pick: Qty Part number Description Batch 1 AN4-10A Bolt <u>B17073</u> <u>x12</u> <i>mjl</i>
7.0	AN44A	Bolt
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) Bolt Pick: Qty Part number Description Batch 1 AN4-4A Bolt <u>M100857</u> <u>x12</u> <i>mjl</i>
8.0	AN960JD416	Washer
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s) Washer Pick: Qty Part number Description Batch 2 AN960JD416 Washer <u>M101938</u> <u>x30</u> <i>mjl</i>
9.0	MS20470AD45	Rivet, Universal Head
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s) Rivet, Universal Head Pick: Qty Part number Description Batch 2 MS20470AD4-5 Rivet <u>M102455</u> <u>x30</u> <i>mjl</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty	Part number	Description	Batch
2	MS21042L4	Nut	M 19/85 X30



11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2982

ml 07/01/15

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ml 07/01/15 (S)

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 541141

07/01/16 (S) P 07/01/16

14.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/01/17

Job Completion



07/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

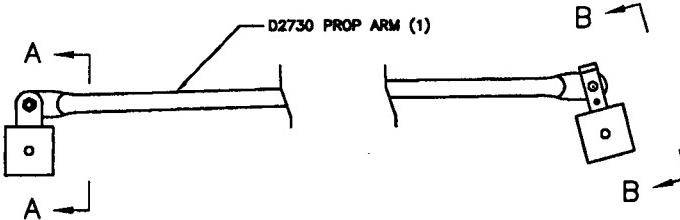
DART

DESIGN RF	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>V</i>	APPROVED <i>M</i>	DRAWING NO. D2982	REV. B SHEET 1 OF 1
DATE 06.04.06		TITLE PROP ARM ASSEMBLY	SCALE NTS
A	00.06.05	NEW ISSUE	
B	06.04.06	MS20470AD4-5 WAS MS20470AD4-6	

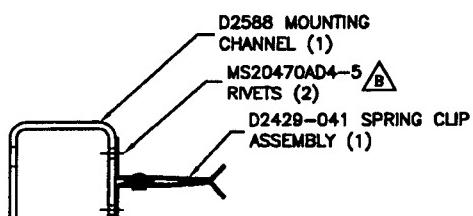
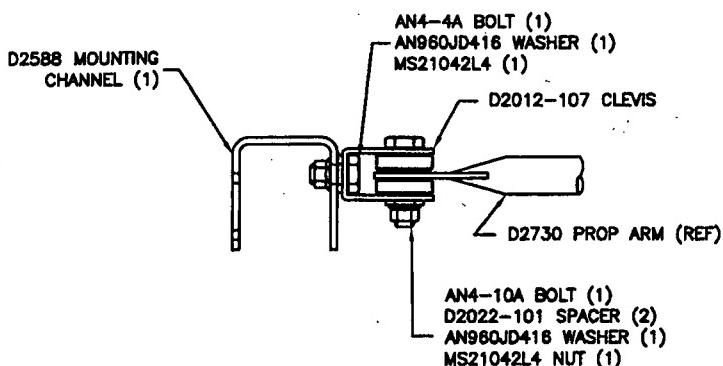
RELEASED

06.04.06

Qty -041	Part Number	Description
X	D2982-041	PROP ARM ASSEMBLY
1	D2012-107	CLEVIS
2	D2022-101	SPACER
1	D2429-041	SPRING CLIP ASSEMBLY
2	D2588	MOUNTING CHANNEL
1	D2730	PROP ARM
1	AN4-10A	BOLT
1	AN4-4A	BOLT
2	AN960JD416	WASHER
2	MS20470AD4-5	RIVET
2	MS21042L4	NUT (OR MS21042-4)

D2982-041 PROP ARM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29023

SECTION B-B

(PROP ARM REMOVED FOR CLARITY)

SECTION A-A

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